

5/26







DART AEROSPACE LTD	Work Order:	23535
Description: Pedal Lock Cover	Part Number:	D3368-3
Dwg: D3368 Rev. <i>30</i>	Qty:	10
Page 1 of 1		


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>[Signature]</i>	05.06.08	10
2	MV	Cut blank: 2.00" x 2.00" x 10.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B2.000x02.000) Identify for D3368-3 Batch: <i>M17/24</i>	<i>J.L</i>	05/06/20	10
3	MV	Machine D3368-3 as per Folio FA500 and Dwg D3368 Identify as D3368-3	<i>J.L</i>	05/06/23	10
4	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	05/06/23	10
5	QC8	Second check	<i>[Signature]</i>	05.06.23	10
6	MV	Deburr	<i>J.L</i>	05/06/23	10
7	QC5	Inspect work to Step 6	<i>[Signature]</i>	05.06.24	10
8	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>[Signature]</i>	05/7/4	10
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	<i>[Signature]</i>	05/11/15	10
10	QC3	Inspect Powder Coat	<i>CJ</i>	05/11/16	10
11	ST	Identify and Stock	<i>[Signature]</i>	05/11/16	10
12	AC	Cost / part <i>36.16</i>	<i>[Signature]</i>	05-11-21	10
13	DC	Close W/O <i>51.38</i> Inspect Level 21	<i>[Signature]</i>	05/11/20	10

Rev	Date	Change	Revised By	Approved
A	05.01.27	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.01.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/22	3	- 1 piece tapered hole is off center - 1 piece 2 tapered holes passed right thru	 05.06.23 	- 1st is acceptable to be off the center 0.015" - Tap the hole from outside surface grind flush.	05/06/22 S.L.		 05.06.23  05/06/22	 05.11.22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	23535
Description: Pedal Lock Cover		Part Number:	D3368-3
Inspection Dwg: D3368	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.254	✓			
7.250	+/-0.010	7.258	✓			
0.650	+/-0.010	0.648	✓			
0.107	+/-0.010	0.107	✓			
1.800	+/-0.010	1.801	✓			
45°	+/-0.5°	45°	✓			
Ø0.201	+/-0.010	0.201	✓			
Ø1.300	+/-0.010	1.295	✓			
Ø1.400	+/-0.010	1.400	✓			
Ø1.031	+/-0.010	1.029	✓			
0.250	+/-0.010	0.250	✓			
1.500	+/-0.010	1.499	✓			
1.440	+/-0.010	1.442	✓			
2.00	+/-0.030	1.995	✓			
7°	+/-0.5°	7°	✓			
0.635	+0.010/-0.000	0.640	✓			
Ø1.250	+/-0.005	1.245	✓			
0.250 deep	+/-0.010	0.250	✓			
1.000	+/-0.010	0.995	✓			
1.450	+/-0.010	1.451	✓			
0.375	+/-0.010	0.371/0.372	✓			
0.310	+/-0.010	0.309	✓			
Ø0.750	+0.010/-0.000	0.755	✓			
Ø0.136	+/-0.010	0.139	✓			
Ø0.185	+0.005/-0.000	0.185	✓			

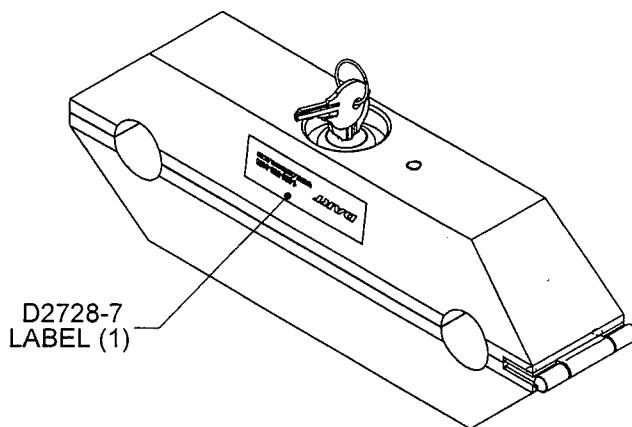
Measured by:	Er	Audited by:	JE	Prototype Approval:	N/A
Date:	05/06/21	Date:	05.06.23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	

RELEASED
050525



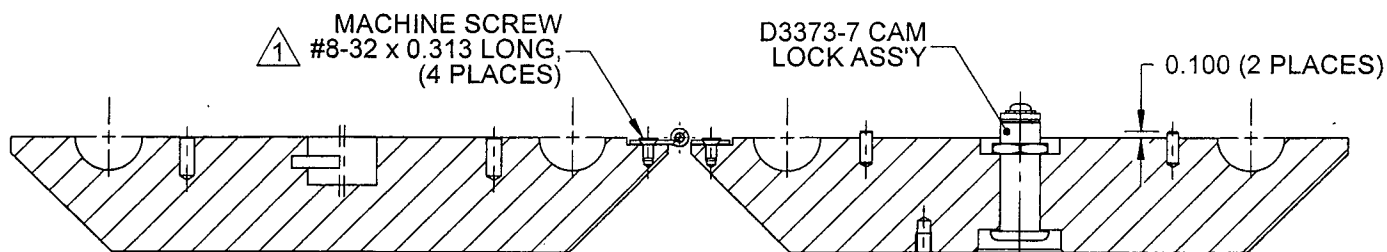
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



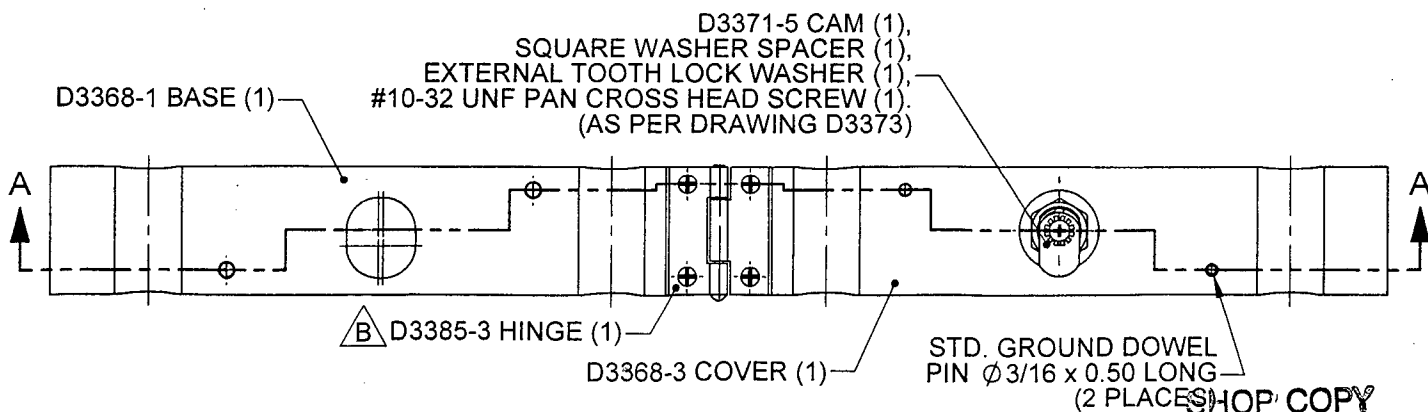
D2728-7
LABEL (1)

RELEASED
[Signature]
05/04/20

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAUR P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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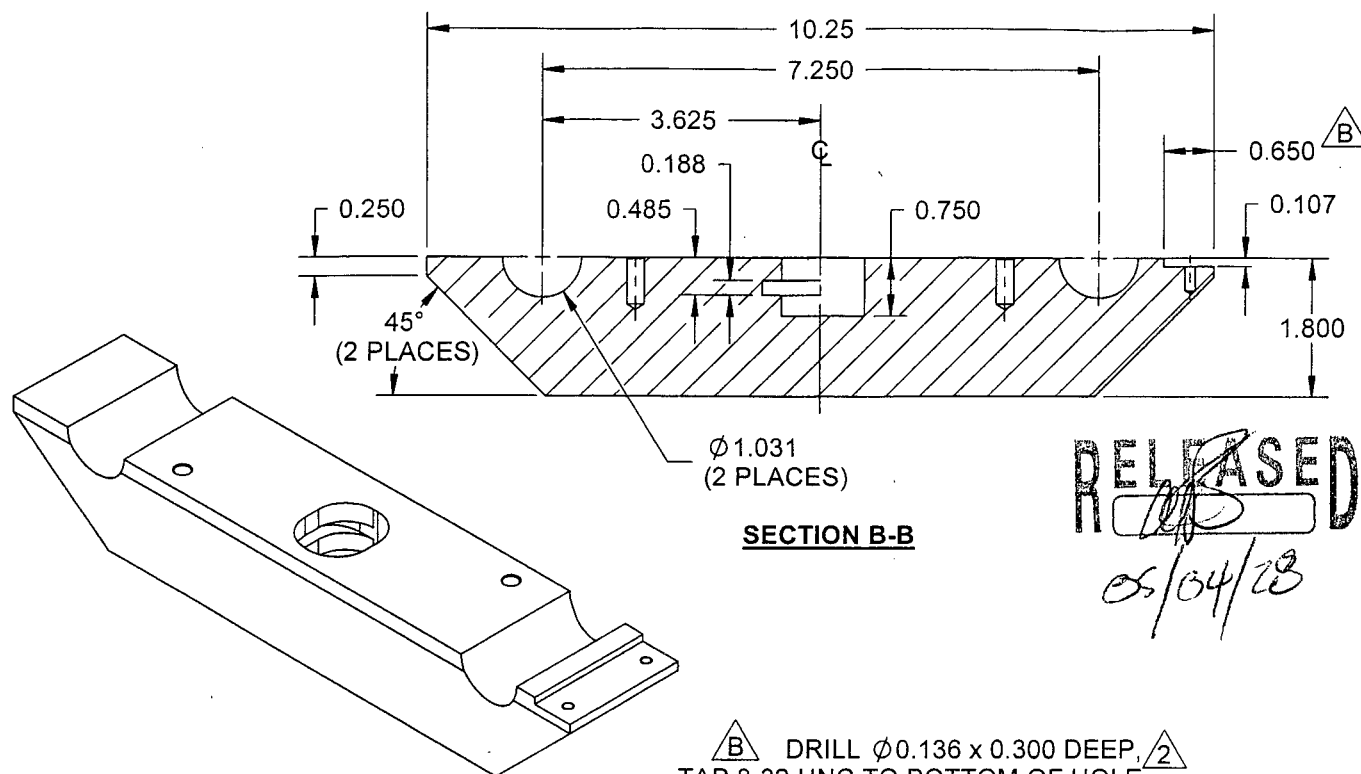
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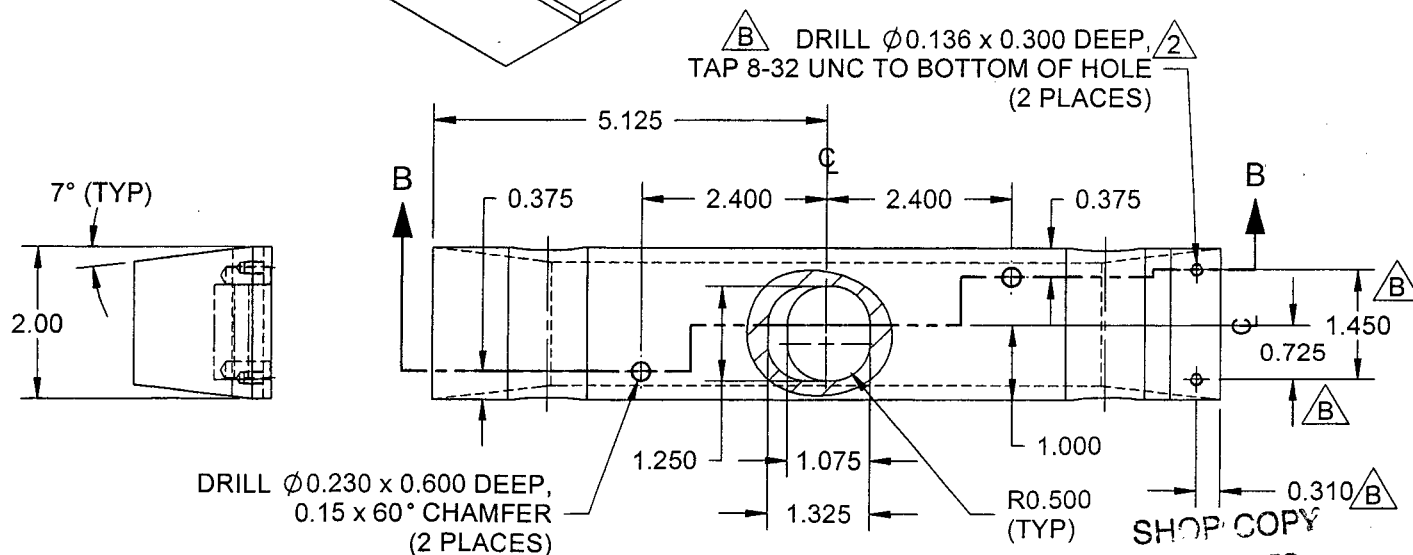
23535



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



RELEASED
05/04/23



D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

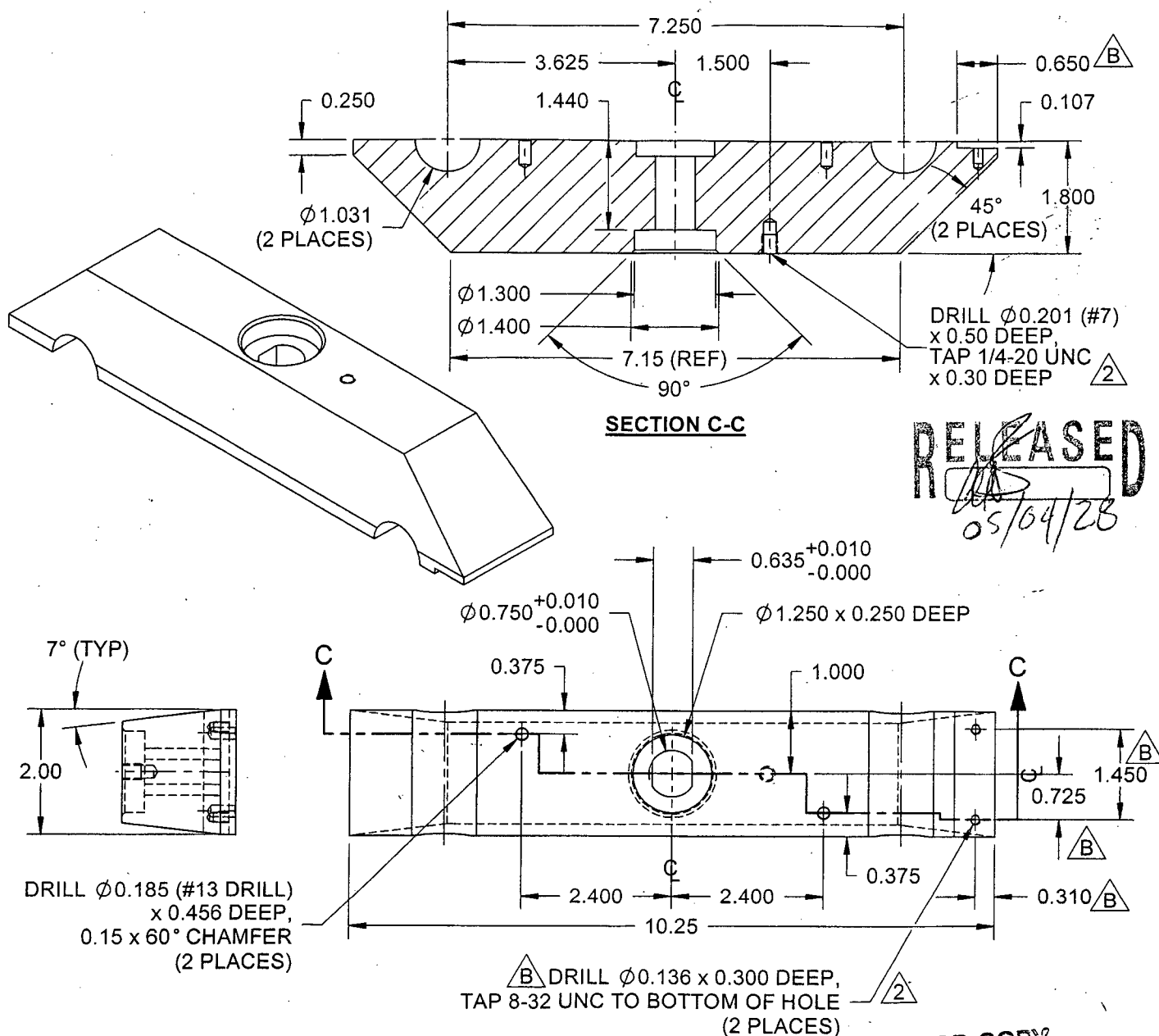
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



RELEASED
05/04/28

D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005.4/3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 23535

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 07, 2005

11:54 am

Work Order No : 0023535
Project Name : D3368-3
Project For : WK526
Work Order Type : Main
Main WO Number :
House Part Number : D3368-3
Description : Pedal Lock Cover
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 06-07-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

JL 3299-1
no work in
progress

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:29 am

Work Order No : 0023535
Project Name : D3368-3
Project For : WK526
Work Order Type : Main
Main WO Number :
House Part Number : D3368-3
Description : Pedal Lock Cover
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 06-07-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	13.50	100.00		
Production Cost :	0.00	254.54	100.00	0.00	254.54
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	13.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	254.54	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	254.54			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-254.54)

MIS 01/B
u
11-13

Date: Monday, 14/11/2005 8:50:52 AM
 User: Alba Panzuto

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK COVER
Job Number : 23535	
Estimate Number : 10445	
P.O. Number :	Part Number : D33683
This Issue : 14/11/2005 S.O. No. :	Drawing Number : D3368 REV B
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By :	Due Date : 30/11/2005 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est. A 05.01.27 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"
-----	--------------------	-------------------------

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: Machine D3368-3 as per Folio FA500 and Dwg D3368
 Identify as D3368-3
 Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
 Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Date: Monday, 14/11/2005 8:50:52 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK COVER

Job Number: 23535

Part Number: D33683

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

